

Work Order ID 59334

June 1, 2010 2:31:37 PM



Page 1

Item ID: D3187-1

Accept

Revision ID:

Item Name: Spacepod Floor

Start Date: 6/01/10 Start Qty: 5.00

Required Date: 6/04/10 Req'd Qty: 5.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan: CL

Date: 10/6/11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3187

Rev C

100



FLOW WATER JET

0.00

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3187 ☐ Dwg Rev: C ☐ Prog Rev: C ☐ 2-
Deburr if necessary

6061 .050

B10-6-21

(6)

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

TEMPLATE DT3187-1T1

B10-6-21

120



QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

S 10/06/12

(75)

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59334

June 1, 2010 2:31:37 PM

Page 2

2 Rack

Item ID: D3187-1

Accept



Revision ID:

Setup Start



Item Name: Spacepod Floor

Stop



Start Date: 6/01/10 Start Qty: 5.00



Cust Item ID:

Required Date: 6/04/10 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
140 Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 <i>M 112538</i> Memo START TIME: <i>10:00</i> <input type="checkbox"/> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>10:30</i>	0.00 0.00							
150 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							

6 BR 10-6-23

6 BR 10-6-24

M 10 06 24 6

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59334

June 1, 2010 2:31:37 PM

Page 3

Item ID: D3187-1

Accept

Revision ID:

Item Name: Spacepod Floor

Start Date: 6/01/10 Start Qty: 5.00

Required Date: 6/04/10 Req'd Qty: 5.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



Small Fab

Small Fab

0.00

Memo

0.00

1- install D2986-1 rubber spacer using contact cement and trim to fit if necessary as per dwg D3187 A/R contact cement Batch: 112983 2- transfer holes from spacepod floor to rubber spacer

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Soloslog

46

180



Packaging

Packaging

Identify as per dwg & Stock Location 241A

Memo

0.00

0.00

10/8/10

WSP

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59334

June 1, 2010 2:31:37 PM



Page 4

Item ID: D3187-1

Accept



Setup

Start



Revision ID:

Stop



Item Name: Spacepod Floor

Start Date: 6/01/10

Start Qty: 5.00



Cust Item ID:

Required Date: 6/04/10

Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/08/10
MF
10-8-10

Picklist Print

June 1, 2010 2:31:36 PM

Page 1

Work Order ID: 59334

Parent Item: D3187-1

Parent Item Name: Spacepod Floor

Comments: IPP: C05.04.14 Now a purchased part KJ/JLM
IPP Rev:D Now On Waterjet 07-04-19 JLM
IPP Rev:E Now Powder Coated 07-05-24 JLM
IPP Rev:F 09-01-20 rev.c as per dwg DD verified by:EC

Start Date: 6/01/10

Start Qty: 5.00

Required Date: 6/04/10

Required Qty: 5.00

D2986-1

Manufactured No



Rubber Spacer

B60770+6 100

Each

3.0000

1

5



10-08-09

Location

Loc Qty

Loc Code

ST242

3

57659

3

M6061T6S.050

Purchased

No

160

sf

167.0900

7.43

39.10526

44.6



6061-T6 .050 Sheet



10-6-21

Location

Loc Qty

Loc Code

MAT

128

114799

128

MAT21

39.09

110791

4.5

113216

31.59

17349

3

114993

114993

(6)

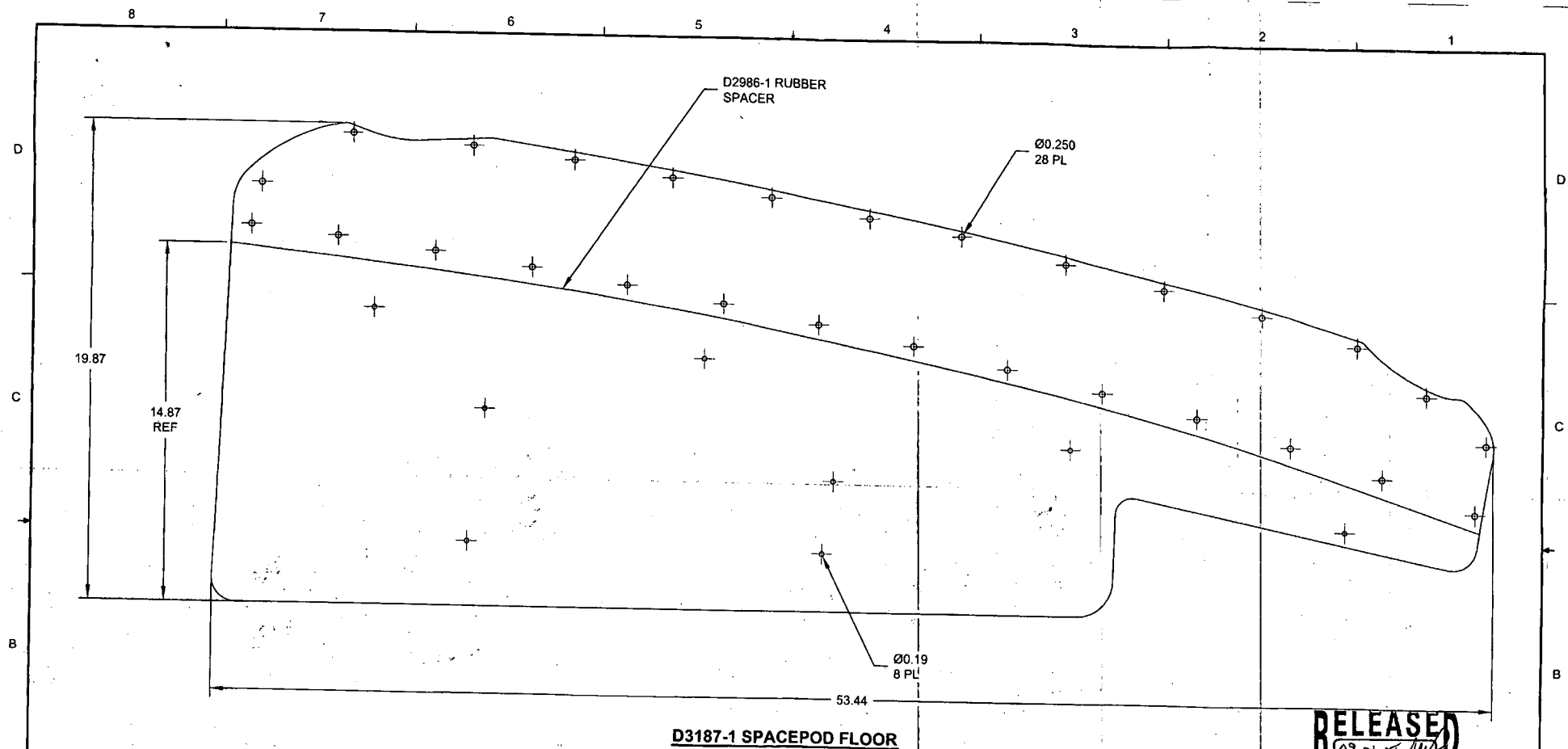
W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries









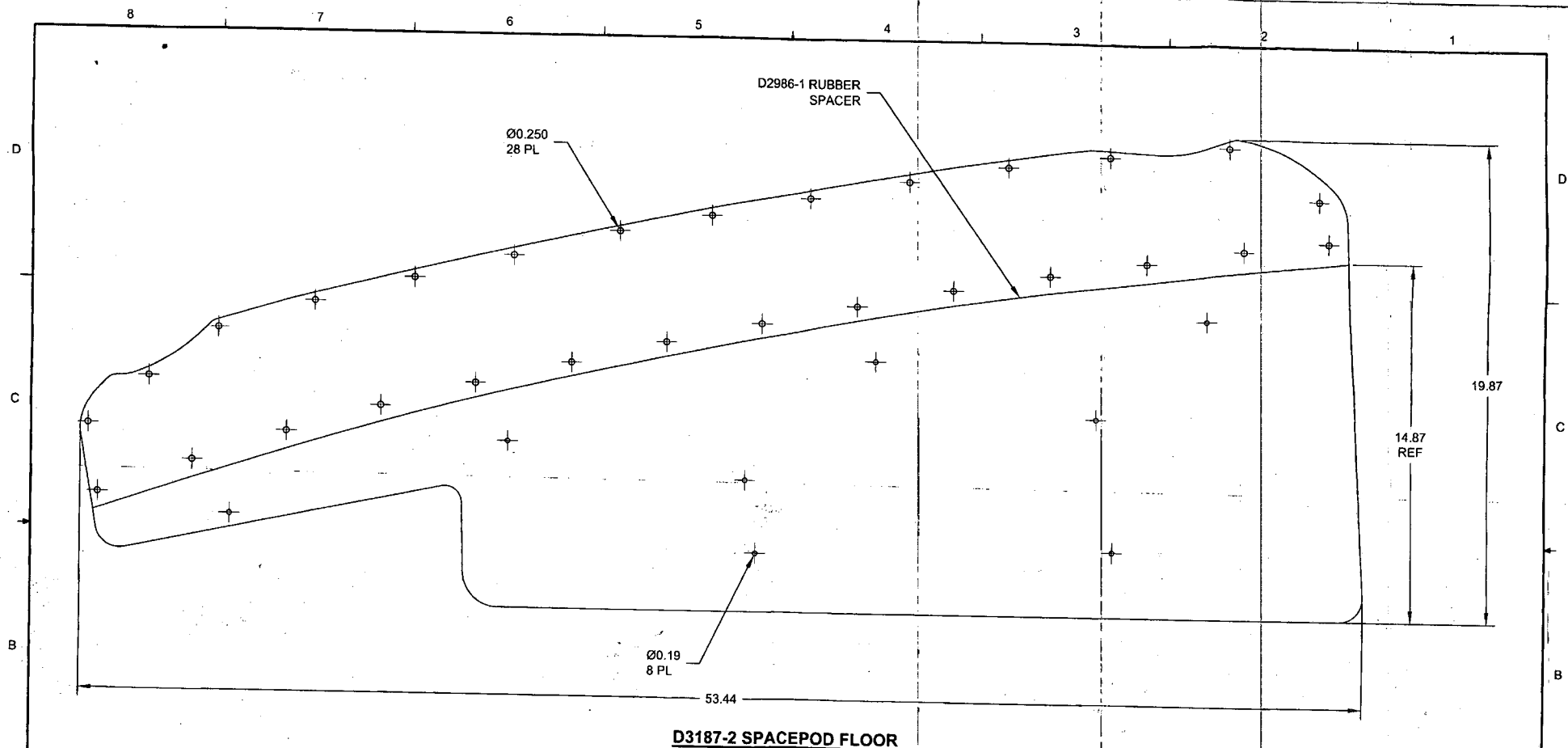
D3187-1 SPACEPOD FLOOR

D3187-1 SPACEPOD FLOOR NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC. M6061T6S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3187-1" USING WHITE FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 4.2 LBS
- 8) TOOLING: CUT/DRILL PER TEMPLATE DT3187-1T1
- 9) AFTER FINISH, INSTALL D2986-1 RUBBER SPACER USING CONTACT CEMENT. TRIM TO FIT

RELEASED
09.01.05 MB

C	REDRAWN TO CURRENT STANDARDS; TRANSFERRED TO B-SIZE FORMAT; ADDED SHEET 2; CREATED DETAIL FOR D3187-2; REVISED SHEET 1 NOTES. REASON: CLARIFIED DRAWINGS FOR D3187-1/-2.			MB	09.01.05
B	CHANGE SHAPE			CP	03.05.16
A	NEW ISSUE			CP	03.03.31
REV.	DESCRIPTION			BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. C SHEET 1 OF 2	
DRAWN					
CHECKED		DRAWING NO. D3187		SCALE	
MFG. APPR.		TITLE		NTS	
APPROVED		SPACEPOD FLOOR			
DE APPR.					
DATE	09.01.05	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



D3187-2 SPACEPOD FLOOR NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC. M6061T6S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3187-2" USING WHITE FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 4.2 LBS
- 8) TOOLING: CUT/DRILL PER TEMPLATE DT3187-1T1
- 9) AFTER FINISH, INSTALL D2986-1 RUBBER SPACER USING CONTACT CEMENT. TRIM TO FIT

RELEASED
09.01.05 JMB

DESIGN	1	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	2		
CHECKED	3	DRAWING NO.	REV. C
MFG. APPR.	4	D3187	SHEET 2 OF 2
APPROVED	CAN 5	TITLE	SCALE
DE APPR.		SPACEPOD FLOOR	NTS
DATE	09.01.05	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			